

Date: Tuesday, 9/25/2007 10:11:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 34843	
Estimate Number : 10771	
P.O. Number : N/A	Part Number : D3462042
This Issue : 9/25/2007 S.O. No. : N/A	Drawing Number : D3462 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 33703	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/10/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : EST REV. A 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34621	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1	Base Flat Pattern	B33531 -> 1*

B34219 -> 3*

PD 07-10-02 (4)

2.0	D34623	Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	B33823 -> 1*

B33711 -> 3*

PD 07-10-02 (4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

PD 07-10-02 (4)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

10/7/03 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10/10/03 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/25/2007 10:11:49 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34843

Part Number: D3462042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(P10) →

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

U 07-10-04 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



See GC
for inspection



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 02/10/05 24-042

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

U 07/10/05 (4)

9.0

QC21

FINAL INSPECTION W/O RELEASE



(4)

Comment: FINAL INSPECTION W/O RELEASE

207/10/10

Job Completion



U 07-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3462-042 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: DD Date: 07/10/10
 QA: N/C Closed: JD Date: 07.10.10

NCR: <u>34843</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/05	6.0	Powder coat D.D. not adhere to part in a section of 1/2" square area.	<i>[Signature]</i>	Build area of where the paint didn't adhere and sand the total part.	07-10-05 <i>[Signature]</i>	En 07/10/05	<i>[Signature]</i>	En 07/10/05
		R.C. Human error part wasn't cleaned enough.	<i>[Signature]</i>	Re Powder coat as per Q52005	07/10/05 <i>[Signature]</i>	En 07/10/05	<i>[Signature]</i>	En 07/10/05

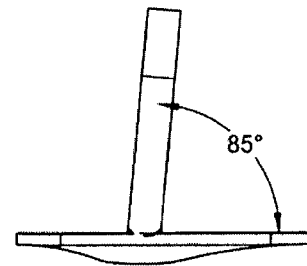
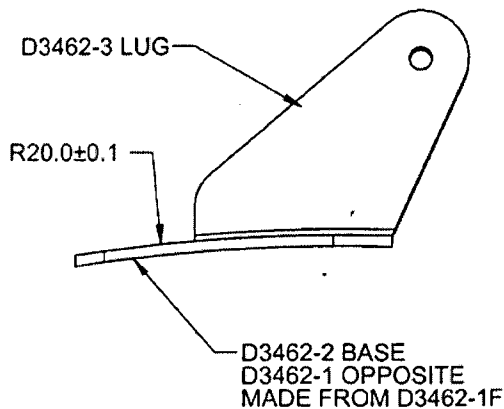
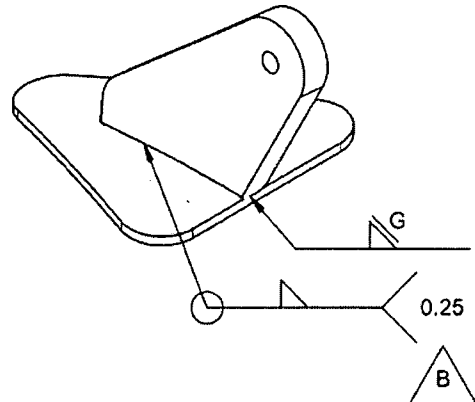
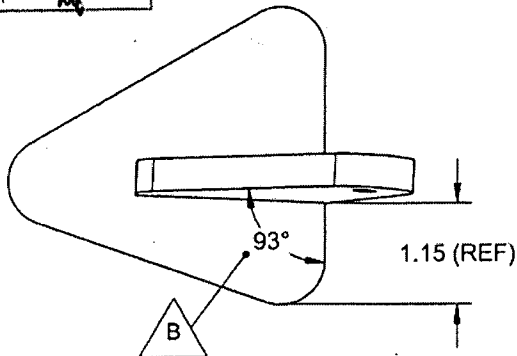
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3462	REV. B SHEET 1 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIMENSIONS	

RELEASED

05.12.09 H



D3462-042 BRACKET ASSEMBLY (SHOWN)
D3462-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 34843

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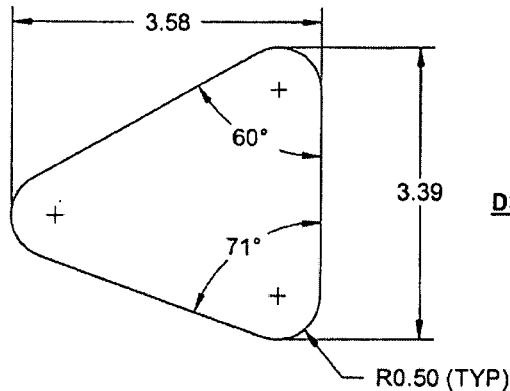
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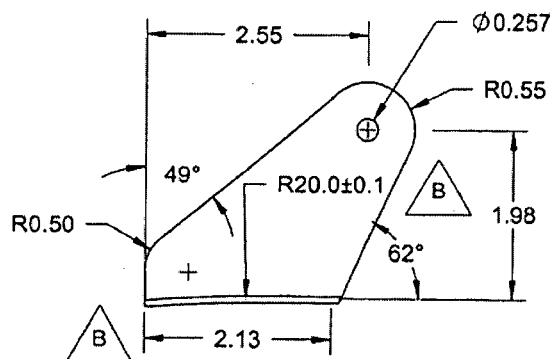
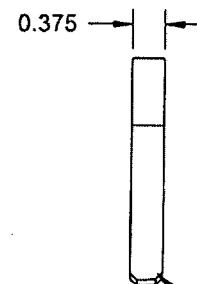
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3462	REV. B SHEET 2 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED

05.12.09 #

**D3462-1F FLAT PATTERN****D3462-1F BASE**

- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK (REF. DART SPEC. M304S11 GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

**D3462-3 LUG**0.08 x 45°
CHAMFER
(TYP)RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 34843

D3462-3

- 1) MATERIAL: AISI 304 SS BAR (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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